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Bibliography

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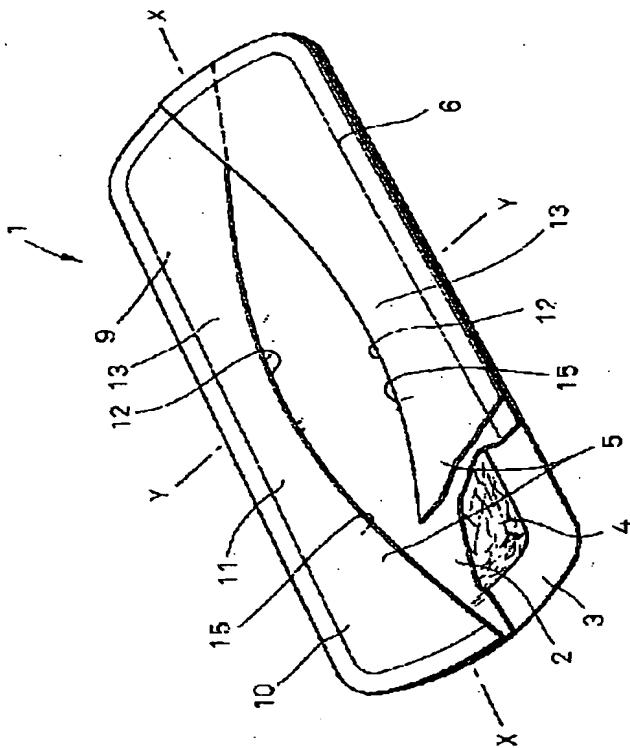
An epitome

(57) [Abstract]

[Objects of the Invention] Dirt and the humid feeling of the skin at the time of wear of a sanitary napkin are mitigated.

[Elements of the Invention] In a sanitary napkin 1, a residual portion is covered with the liquid resistance sheet 5 of a left Uichi pair except for a crosswise center section which will contact on vaginal opening of the surface sheet 2, and the outskirts of it.

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CLAIMS

[Claim(s)]

[Claim 1] In a sanitary napkin with which an absorbent core comes to intervene between a liquid permeability surface sheet and a non-liquid permeability rear-face sheet Extend in a cross direction of said napkin and the outside periphery section joins to said napkin upper surface order both ends and the side edge section. A pocket which carries out a opening toward said center line while covering the periphery section of said surface sheet by being located in center line approach to

which an inside edge bisects the cross direction of said napkin is formed. And said napkin characterized by preparing a liquid resistance sheet of a left Uichi pair to which a crosswise center section of said surface sheet is made to expose, being large and having narrowed a gap of said inside edge of a sheet of this pair at both ends in the center section of said napkin cross direction.

[Claim 2] A napkin according to claim 1 with which said covering sheet elongates an elasticity sheet to said cross direction.

[Claim 3] A manufacture method characterized by including the next production process of a sanitary napkin with which an absorbent core comes to intervene between a liquid permeability surface sheet and a non-liquid permeability rear-face sheet.

- a. A production process which supplies continuously a main part of a napkin with which a core comes to intervene between said surface sheets and rear-face sheets in the state of a column.
- b. A production process which supplies continuously a band-like liquid resistance sheet original fabric to a longitudinal direction.
- c. A production process bisected right and left by cutter which repeats and draws a same waveform along with the center line while rocking said original fabric right and left about the center line.
- d. A production process which delays substantially [said wave] supply of either right and left of said bisected original fabric by 1/2 pitch.
- e. A production process which only necessary distance makes isolate said bisected original fabric crosswise.
- f. A production process which lays said original fabric in a surface sheet of a main part of a napkin, and is joined after said two production processes d and e.
- g. A production process which omits a main part of a napkin which joined said original fabric according to an individual, and obtains said napkin.

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DETAILED DESCRIPTION

[Detailed Description of the Invention]

[0001]

[Industrial Application] This invention relates to a sanitary napkin and its manufacture method.

[0002]

[Description of the Prior Art] Various technology which raises the feeling of wear of this napkin is known by maintaining the skin contact side of a sanitary napkin at dryness conventionally. For example, when a napkin is worn, the sanitary napkin which arranged the hydrophobic plastic film which has much puncturing in the central region of the surface sheet with which ostium vaginae counter, and arranged the hydrophobic nonwoven fiber cloth which has much puncturing on the outside of a central region is indicated by JP,1-122727,U.

[0003]

[Problem(s) to be Solved by the Invention] Since the surface sheet consists of hydrophobic plastic film and nonwoven fiber cloth according to said well-known technology, menstrual blood does not remain on a surface sheet and shifts to a core. However, if a wearer's body pressure is applied to a napkin, menstrual blood will produce the problem of giving a reverse sink and a wearer a humid feeling to the surface sheet upper surface from a core.

[0004] Then, this invention makes it the technical problem to solve said problem by covering the portion of the remainder except the central region of the surface sheet of a napkin with a liquid resistance sheet.

[0005]

[Means for Solving the Problem] The place made into a means in order that this invention may solve said technical problem is as follows.

[0006] It is premised on a sanitary napkin with which an absorbent core comes to intervene between a liquid permeability surface sheet and a non-liquid permeability rear-face sheet in this invention.

[0007] In this premise, extend in a cross direction of said napkin and the outside periphery section joins to napkin upper surface order both ends and the side edge section. An inside edge is located in center line approach which bisects the cross direction of a napkin, and forms a pocket of a surface sheet which carries out a opening toward a center line while covering the periphery section at least. And a liquid resistance sheet of a left Uichi pair to which a part for a crosswise center section of a surface sheet is made to expose is prepared, and it is the feature of this invention for it to be large in the center section of the cross direction of a napkin, and to have narrowed a gap of an inside edge of a sheet of this pair at both ends.

[0008] Moreover, it is that feature that a manufacture method of a sanitary napkin concerning this invention includes the following production process for a manufacture method of a sanitary napkin that an absorbent core comes to intervene

between a liquid permeability surface sheet and a non-liquid permeability rear-face sheet.

- a. A production process which supplies continuously a main part of a napkin with which a core comes to intervene between a surface sheet and a rear-face sheet in the state of a column.
- b. A production process which supplies continuously a band-like liquid resistance sheet original fabric to a longitudinal direction.
- c. A production process bisected right and left by cutter which repeats and draws a same waveform along with the center line while rocking said original fabric right and left about the center line.
- d. Production process which delays substantially [said wave] supply of either right and left of a bisected original fabric by 1/2 pitch.
- e. Production process which only necessary distance makes isolate a bisected original fabric mutually crosswise.
- f. A production process which lays an original fabric in a surface sheet of a main part of a napkin, and is joined after said two production processes d and e.
- g. A production process which omits a main part of a napkin which joined said original fabric according to an individual, and obtains a napkin.

[0009]

[Function] Thus, in the constituted sanitary napkin, a wearer's skin is not soiled in the covered portion with the menstrual blood which flowed backwards from the core by a liquid resistance sheet's being permeability or non-permeability, meaning the sheet of non-liquid permeability or difficulty liquid permeability, and covering a surface sheet with the sheet which a pair requires partially.

[0010] The liquid resistance sheet forms the pocket with the surface sheet, and the menstrual blood which advanced into the pocket penetrates the surface sheet in a pocket, and is absorbed by the core.

[0011] In the manufacture method of this napkin, after dividing into two by the cutter which rocks a liquid resistance sheet original fabric right and left, the bisected original fabric is arranged at bilateral symmetry by delaying by 1/2 wave-like pitch on which a cutter draws one supply of them.

[0012]

[Example] It is as follows when it explains based on the sanitary napkin concerning this invention, and the drawing of attachment of the details of that manufacture method:

[0013] Drawing 1 and 2 are the partial fracture perspective diagrams and X-X-ray cross sections of a napkin 1. The absorbent core 4 comes to intervene between the liquid permeability surface sheet 2 and the non-liquid permeability rear-face sheet 3, and a napkin 1 has the liquid resistance sheet 5 of a left Uichi pair in the upper surface of the surface sheet 2. The portion which extends from the periphery of a core 4 has joined the table rear-face sheets 2 and 3 by the seal line 6 with the periphery edge of the liquid resistance sheet 5. A napkin 1 has the edges 9 and 10

and pars intermedia 11 of a cross direction, and has center line X-X which bisects right and left, and center line Y-Y which bisects order. alienation of free edge 13 which the liquid resistance sheet 5 has the inside free edge 13 on which the cutline 12 of the letter of a sign curve is drawn along with center line X-X, and counter — a size is the largest in pars intermedia 11, becomes small gradually toward edges 9 and 10, and overlap mutually at the edges 9 and 10. Thus, the free edge 13 to estrange can expose the surface sheet 2 so that it may contact only the vaginal opening and near the wearer. Moreover, the liquid resistance sheet 5 forms the pocket 15 in which the free edge 13 carries out a opening toward center line X-X as shown in drawing 2 with the surface sheet 2.

[0014] Thus, in the constituted napkin 1, liquid permeability nonwoven fabric and puncturing sheet plastic can be used for the surface sheet 2, and the plastic film of non-liquid permeability can be used for the rear-face sheet 3. The mixture of grinding pulp, grinding pulp, and high absorptivity polymer etc. can be used for a core 4. It is permeability or non-permeability and plastic film and the nonwoven fabric of non-liquid permeability or difficulty liquid permeability can be used for the liquid resistance sheet 5. If the sheet of elasticity is elongated and used to the cross direction of a napkin 1 as this liquid resistance sheet 5, when the cross direction of a napkin 1 curves to the rear-face sheet 3 side, the liquid resistance sheet 5 will contract, and opening of the pocket 15 shown in drawing 2 will come to open greatly.

[0015] If this napkin 1 is worn, the body fluid of menstrual blood and others will permeate a core 4 from the portion which the surface sheet 2 exposed, and also will enter into a pocket 15, will permeate a core 4 from there, and will be further diffused to right and left within a core 4 approximately. Moreover, on the worn napkin 1, body pressure may be applied in the vertical direction and the once absorbed menstrual blood may flow backwards to the surface sheet 2 upper surface. However, with this napkin 1, since the periphery section is covered with the liquid resistance sheet 5, the skin is not soiled with the menstrual blood which flowed backwards, or a humid feeling is not raised. Since the liquid resistance sheet 5 was especially piled up at the edges 9 and 10 of a napkin 1 and it was made the duplex, the extraction prevention effect of the menstrual blood which flowed backwards is high.

[0016] Drawing 3 is the mimetic diagram of the manufacturing process of a napkin 1.

[0017] At the production process I of drawing 3, the continuum 125 of the main part of a napkin which consists of an absorbent core 104 according to individual by which opens a necessary column gap between the continuous liquid permeability surface sheet 102, the continuous impermeable rear-face sheet 103, and these sheets 103 and 104, and it is placed between them is put on the endless belt 126, and is supplied.

[0018] the cutter 136 which supplies continuously the liquid resistance sheet original fabric 135 which has elasticity in the length direction from the longitudinal direction at a production process II, and repeats and draws the cutline of the same configuration on the both sides substantially along with the center line of an original

fabric 135 — dividing into two — the liquid resistance sheet of a left Uichi pair — a continuum 137 is obtained.

[0019] a production process III — the liquid resistance sheet of a pair — one supply of a continuum 137 — supply of another side — a part for 1/2 pitch of a cutline — delaying — further — both — only necessary distance isolates at least one side of a continuum 137 in the direction of arrow head Y — making — and — both — only a necessary scale factor extends a continuum 137 to a travelling direction.

[0020] the sheet elongated at the production process IV — the seal line 6 which supplies a continuum 137 on the surface sheet 102 of the continuum 125 of the main part of a napkin, and subsequently meets the periphery of each core 104 using the embossing machine 142 — both — continua 125 and 137 are joined.

[0021] At a production process V, the joined continuum 125,137 is judged by the cutter 143, and the napkin 1 according to individual is obtained.

[0022] Drawing 4 is the plan of the liquid resistance sheet original fabric 135 bisected by right and left in a production process II. rock a cutter 136 right and left centering on center line C-C of an original fabric 135, and make it draw the cutline 140 of the letter of a sign curve at a production process II — the liquid resistance sheet of a left Uichi pair — a continuum 137 (137A, 137B) is obtained. a production process III — either of these continua 137A and 137B, for example, a continuum, — supply of 137B — the continuum of another side — it considers as continuum 137B' which delays by 1/2 pitch of a sign curve to supply of 137A, and is made to carry out the parallel displacement only of the necessary distance d to the left, and is shown by the imaginary line. in this way — a continuum — the mutual valleys produced by the cutline 140 isolate and counter right and left, and 137A and 137B' will be in the arrangement condition of bilateral symmetry that mountains overlap.

[0023] drawing 5 — a production process IV — setting — the surface sheet 102 — a liquid resistance sheet — a continuum — it is the plan showing the condition of having laid 137A and 137B'. a continuum — the valley according [137A and 137B'] to those cutlines 140 — the necessary location of a core 104 — usually — the left forward right back — it lays so that it may come in the center mostly. Then, the periphery of a core 104 is joined by the seal line 6.

[0024] Drawing 6 is the same drawing as drawing 4 , and has illustrated one mode of the cutline 140 given to the liquid resistance sheet original fabric 135. Thus, a cutline 140 can also be constituted only in a straight line.

[0025] In the manufacturing process of a napkin 1, in order to join each part material, welding technology can be used or adhesives, such as hot melt adhesive, can be used. Moreover, a non-elasticity sheet can be used for the liquid resistance sheet 5, and the expanding production process of the sheet in a manufacturing process is skipped in that case on it.

[0026]

[Effect of the Invention] Since the surface sheet of the sanitary napkin concerning this invention is covered with the liquid resistance sheet except for the portion

which should contact the vaginal opening to that circumference, it does not soil a wearer's skin with the menstrual blood which flows backwards from an absorbent core, or does not raise a humid feeling.

[0027] Moreover, according to the manufacture method of the sanitary napkin concerning this invention, since it divides into two right and left by the cutline which rocks a liquid resistance sheet original fabric right and left about that center line and bisected each is used as a liquid resistance sheet, in that continuum, the portion which should be discarded hardly arises. Therefore, there is no futility that it is this manufacture method in use of a material.

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DESCRIPTION OF DRAWINGS

[Brief Description of the Drawings]

[Drawing 1] The partial fracture perspective diagram of a sanitary napkin.

[Drawing 2] The Y-Y line cross section of drawing 1 .

[Drawing 3] Typical manufacturing process drawing of a sanitary napkin.

[Drawing 4] The plan of a liquid resistance sheet original fabric.

[Drawing 5] The plan of the sanitary napkin in the production process IV of drawing 3 .

[Drawing 6] The same plan as drawing 4 which shows an example of a cutline.

[Description of Notations]

- 1 Sanitary Napkin
- 2 Surface Sheet
- 3 Rear-Face Sheet
- 4 Core
- 5 Liquid Resistance Sheet
- 9 Ten Edge
- 11 Center Section

15 Pocket

125 Continuum of Main Part of Napkin

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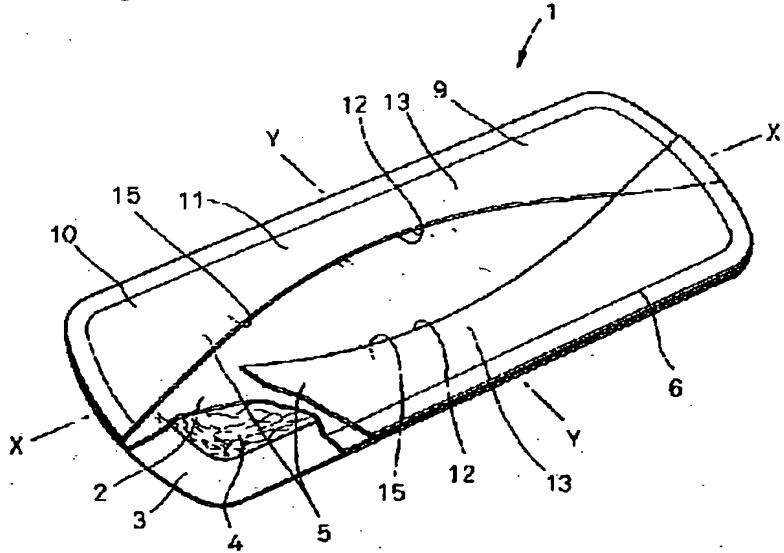
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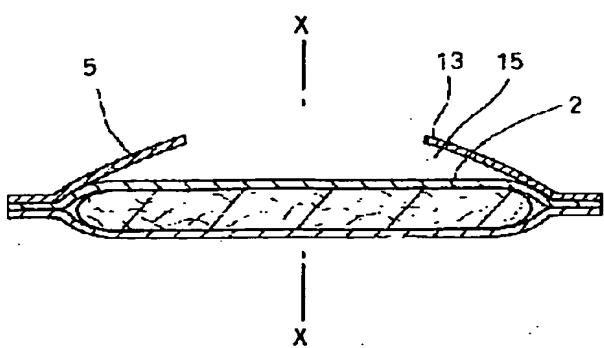
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DRAWINGS

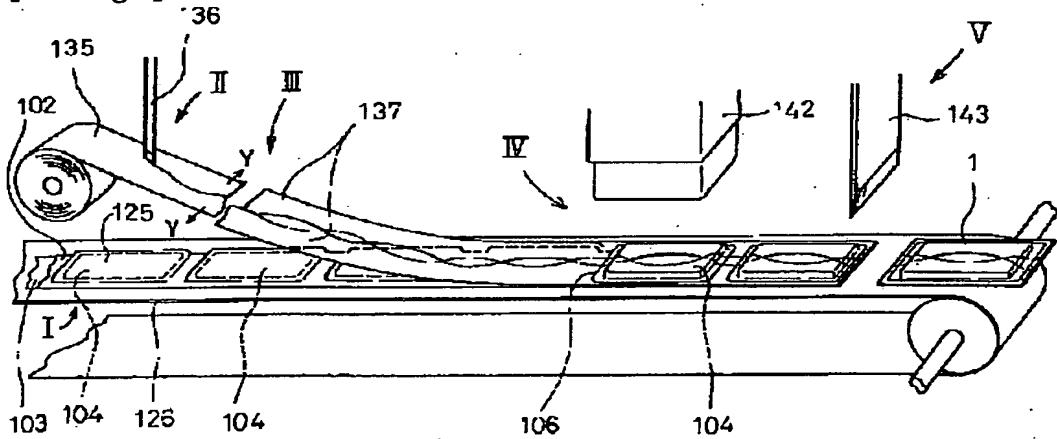
[Drawing 1]



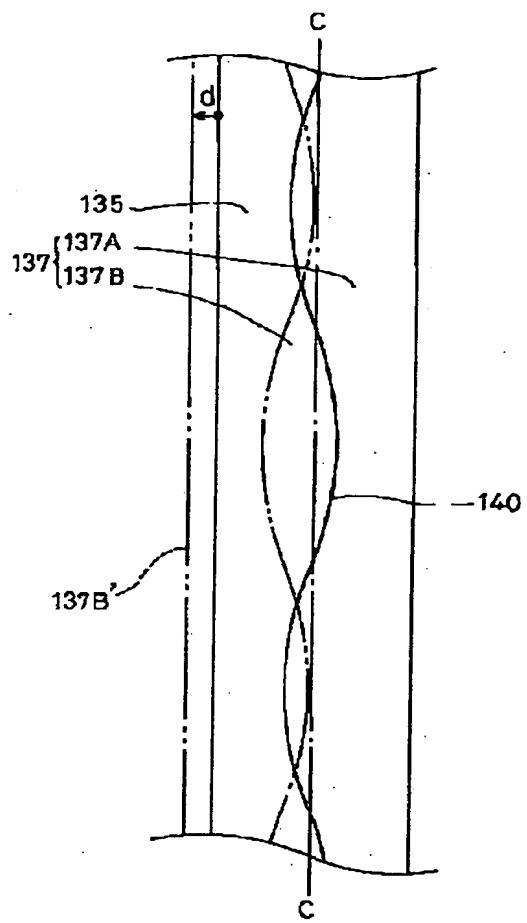
[Drawing 2]



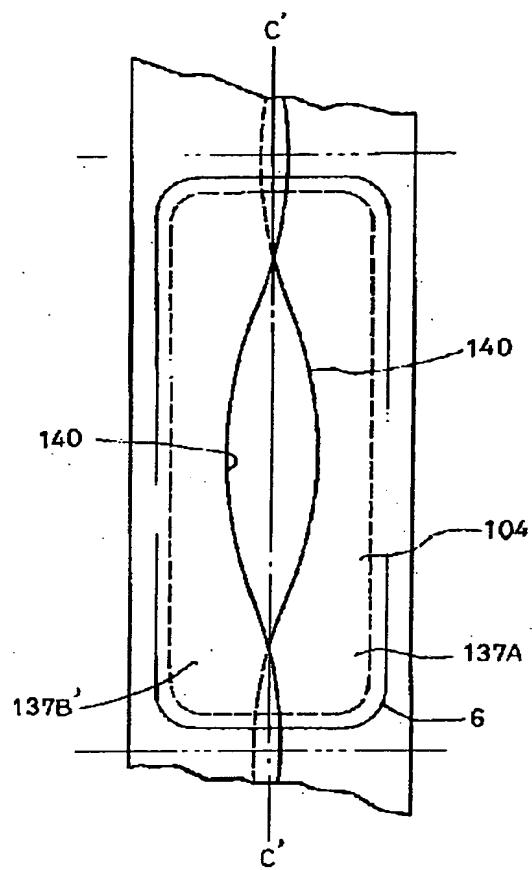
[Drawing 3]



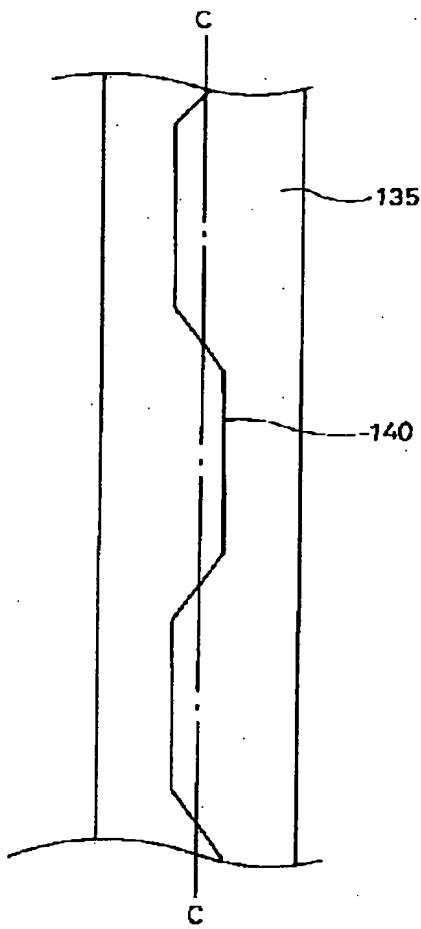
[Drawing 4]



[Drawing 5]



[Drawing 6]



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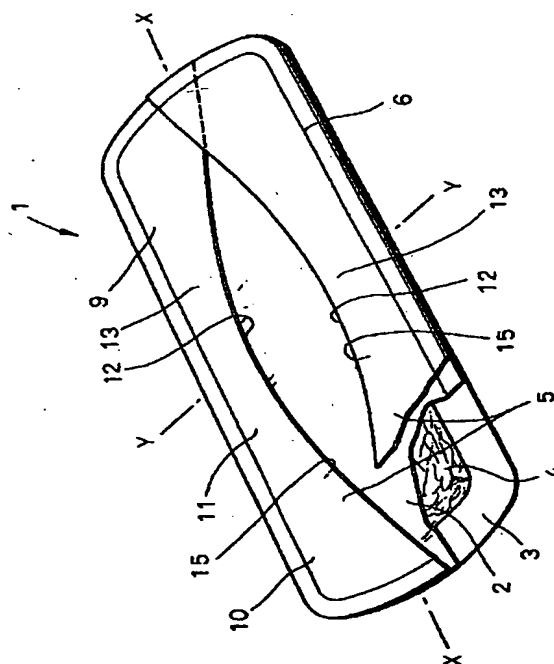
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(54)【発明の名称】 生理用ナプキンおよびその製造方法

(57)【要約】

【目的】 生理用ナプキンの着用時の肌の汚れや湿潤感を軽減する。

【構成】 生理用ナプキン1において、表面シート2の廻りとその周辺に当接することとなる幅方向中央部を除き、残余の部分を左右一対の液抵抗性シート5で被覆する。



1

【特許請求の範囲】

【請求項1】透液性表面シートと不透液性裏面シートとの間に吸液性コアが介在してなる生理用ナプキンにおいて、前記ナプキンの前後方向に延在し、外側周縁部が前記ナプキン上面の前後両端部と側縁部とに接合し、内側縁部が前記ナプキンの幅方向を二分する中心線寄りに位置することにより前記表面シートの周縁部を被覆するとともに前記中心線に向かって開口するポケットを形成し、かつ、前記表面シートの幅方向中央部を露出せしめる左右一対の液抵抗性シートを設け、該一対のシートの前記内側縁部の間隔を前記ナプキン前後方向の中央部で広く、両端部で狭くしてあることを特徴とする前記ナプキン。

【請求項2】前記被覆シートが伸縮性シートを前記前後方向に伸長したものである請求項1記載のナプキン。

【請求項3】透液性表面シートと不透液性裏面シートとの間に吸液性コアが介在してなる生理用ナプキンの次の工程を含むことを特徴とする製造方法。

a. 前記表面シートと裏面シートとの間にコアが介在してなるナプキン本体を縦列状態で連続的に供給する工程。

b. 帯状の液抵抗性シート原反を長手方向に連続的に供給する工程。

c. 前記原反をその中心線に関して左右に揺動しながらその中心線に沿って同一波形を反復して描くカッターにより左右に二分する工程。

d. 二分した前記原反の左右いずれか一方の供給を前記波形の実質的に1/2ピッチ分だけ遅らせる工程。

e. 二分した前記原反を幅方向に所要距離だけ離隔させる工程。

f. 前記二工程d、eの後に前記原反をナプキン本体の表面シートに載置し、かつ、接合する工程。

g. 前記原反を接合したナプキン本体を個別にカットして前記ナプキンを得る工程。

【発明の詳細な説明】

【0001】

【産業上の利用分野】この発明は、生理用ナプキンとその製造方法に関する。

【0002】

【従来の技術】従来、生理用ナプキンの肌当接面を乾燥状態に保つことによって該ナプキンの着用感を向上させる技術は、種々知られている。例えば、特開平1-122727号公報には、ナプキンを着用したときに腔口が対向する表面シートの中央域に多数の開孔を有する疎水性プラスチックフィルムを配し、中央域の外側に多数の開孔を有する疎水性の不織繊維布を配した生理用ナプキンが開示されている。

【0003】

【発明が解決しようとする課題】前記公知技術によれば表面シートが疎水性のプラスチックフィルムおよび不織

繊維布で構成されているから、経血は表面シート上に残ることとなくコアへ移行する。しかし、ナプキンに着用者の体圧がかかると、経血がコアから表面シート上面へ逆流し、着用者に湿潤感を与えるという問題を生じる。

【0004】そこで、この発明は、ナプキンの表面シートの中央域を除く残余の部分を液抵抗性シートで被覆することにより前記問題を解決することを課題にしている。

【0005】

10 【課題を解決するための手段】この発明が前記課題を解決するために手段とするところは、以下のとおりである。

【0006】この発明においては、透液性表面シートと不透液性裏面シートとの間に吸液性コアが介在してなる生理用ナプキンを前提にしている。

【0007】かかる前提において、前記ナプキンの前後方向に延在し、外側周縁部がナプキン上面の前後両端部と側縁部とに接合し、内側縁部がナプキンの幅方向を二分する中心線寄りに位置して表面シートの少なくとも周縁部を被覆するとともに中心線に向かって開口するポケットを形成し、かつ、表面シートの幅方向中央部分を露出せしめる左右一対の液抵抗性シートを設け、該一対のシートの内側縁部の間隔をナプキンの前後方向の中央部で広く、両端部で狭くしてあることがこの発明の特徴である。

【0008】また、この発明に係る生理用ナプキンの製造方法は、透液性表面シートと不透液性裏面シートとの間に吸液性コアが介在してなる生理用ナプキンの製造方法を対象にしており、次の工程を含むことがその特徴である。

a. 表面シートと裏面シートとの間にコアが介在してなるナプキン本体を縦列状態で連続的に供給する工程。

b. 帯状の液抵抗性シート原反を長手方向に連続的に供給する工程。

c. 前記原反をその中心線に関して左右に揺動しながらその中心線に沿って同一波形を反復して描くカッターにより左右に二分する工程。

d. 二分した原反の左右いずれか一方の供給を前記波形の実質的に1/2ピッチ分だけ遅らせる工程。

e. 二分した原反を幅方向に所要距離だけ互いに離隔させる工程。

f. 前記二工程d、eの後に原反をナプキン本体の表面シートに載置し、かつ、接合する工程。

g. 前記原反を接合したナプキン本体を個別にカットしてナプキンを得る工程。

【0009】

【作用】このように構成した生理用ナプキンにおいて、液抵抗性シートとは通気性または非通気性であって不透液性または難透液性のシートを意味し、一对のかかるシートで表面シートを部分的に被覆することにより、その

被覆した部分ではコアから逆流した経血で着用者の肌を汚すことがない。

【0010】液抵抗性シートは、表面シートとともにポケットを形成しており、そのポケットに進入した経血は、ポケット内の表面シートを透過してコアに吸収される。

【0011】かかるナプキンの製造方法においては、液抵抗性シート原反を左右に揺動するカッターで二分したのち、そのうちの一方の供給をカッターの描く波形の1/2ピッチ分だけ遅らせることにより、二分した原反が左右対称に配置される。

【0012】

【実施例】この発明に係る生理用ナプキンとその製造方法の詳細を添付の図面に基づいて説明すると、以下のとおりである。

【0013】図1、2は、ナプキン1の部分断斜視図と、そのX-X線断面図である。ナプキン1は、透液性表面シート2と不透液性裏面シート3との間に吸液性コア4が介在しており、表面シート2の上面には左右一対の液抵抗性シート5を有する。表裏面シート2、3は、コア4の周縁から延出する部分が液抵抗性シート5の外周縁部とともにシールライン6により接合している。ナプキン1は、前後方向の端部9、10と中間部11とを有し、左右を二分する中心線X-Xと、前後を二分する中心線Y-Yとを有する。液抵抗性シート5は、中心線X-Xに沿ってサインカーブ状のカットライン12を描く内側自由縁部13を有し、対向する自由縁部13どうしの離間寸法は中間部11で最も大きく、端部9、10へ向かって次第に小さくなり、端部9、10では互いに重なり合っている。このように離間する自由縁部13は、着用者の膣口とその近傍にのみ当接するよう表面シート2を露出することができる。また液抵抗性シート5は、図2に示すように自由縁部13が中心線X-Xに向かって開口するポケット15を表面シート2とともに形成している。

【0014】このように構成したナプキン1において、表面シート2には、透液性の不織布や開孔プラスチックシートを使用し、裏面シート3には不透液性のプラスチックフィルムを使用することができる。コア4には、粉碎バルブや粉碎バルブと高吸水性ポリマーの混合物などを使用することができる。液抵抗性シート5には、通気性または非通気性であって不透液性または難透液性のプラスチックフィルムや不織布を使用することができる。この液抵抗性シート5として伸縮性のシートをナプキン1の前後方向へ伸長して使用すると、ナプキン1の前後方向が裏面シート3側へ湾曲したときに液抵抗性シート5が収縮し、図2に示したポケット15の口が大きく聞くようになる。

【0015】かかるナプキン1を着用すると、経血その他の体液は、表面シート2の露出した部分からコア4へ

浸透する他に、ポケット15の中に入り、そこからコア4へと浸透し、さらにコア4内で前後、左右へと拡散する。また、着用したナプキン1には上下方向に体圧がかかり、一旦吸収された経血が表面シート2上面へ逆流することがある。しかし、このナプキン1では、周縁部が液抵抗性シート5で被覆してあるから、逆流した経血によって肌を汚したり、潤滑感を高めたりすることがない。特に、ナプキン1の端部9、10では液抵抗性シート5を重ね合わせて二重にしたから、逆流した経血の浸出防止効果が高い。

【0016】図3は、ナプキン1の製造工程の模式図である。

【0017】図3の工程Iでは、連続した透液性表面シート102と、連続した不透液性裏面シート103と、それらシート103と104との間に所要の縦列間隔をあけて介在する個別の吸液性コア104とからなるナプキン本体の連続体125を無端ベルト126に載せて供給する。

【0018】工程IIでは、長さ方向に伸縮性を有する液抵抗性シート原反135をその長手方向から連続的に供給し、原反135の中心線に沿い、その両側に実質的に同一形状のカットラインを反復して描くカッター136で二分し、左右一対の液抵抗性シート連続体137を得る。

【0019】工程IIIでは、一対の液抵抗性シート連続体137の一方の供給を他方の供給よりもカットラインの1/2ピッチ分だけ遅らせ、さらに両連続体137の少なくとも一方を矢印Y方向に所要距離だけ離隔させ、かつ、両連続体137を進行方向に所要倍率だけ延伸する。

【0020】工程IVでは、伸長したシート連続体137をナプキン本体の連続体125の表面シート102上に供給し、次いでエンボス加工機142を使用して個々のコア104の周縁に沿うシールライン6で両連続体125と137とを接合する。

【0021】工程Vでは、カッター143によりその接合した連続体125、137を裁断して個別のナプキン1を得る。

【0022】図4は、工程IIにおいて左右に二分される液抵抗性シート原反135の平面図である。工程IIでは、カッター136を原反135の中心線C-Cを軸として左右に揺動し、サインカーブ状のカットライン140を描かせ、左右一対の液抵抗性シート連続体137(137A、137B)を得る。工程IIIでは、この連続体137A、137Bのいずれか一方、例えば連続体137Bの供給を他方の連続体137Aの供給に対してサインカーブの1/2ピッチ分だけ遅らせ、かつ、左へ所要距離dだけ平行移動させて仮想線で示す連続体137B'とする。かくして連続体137Aと137B'とはカットライン140によって生じる互いの谷どうし

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が左右に離隔して対向し、山どうしが重なり合う左右対称の配置状態となる。

【0023】図5は、工程IVにおいて表面シート102に液抵抗性シート連続体137Aと137B'を載置した状態を示す平面図である。連続体137Aと137B'とは、それらのカットライン140による谷がコア104の所要位置、通常は左右前後のはば中央にくるように載置する。その後、コア104の周縁をシールライン6により接合する。

【0024】図6は、図4と同様な図であって、液抵抗性シート原反135に施すカットライン140の一様を例示している。このように、カットライン140は、直線だけで構成することもできる。

【0025】ナプキン1の製造工程において、各部材を接合するには、融着技術を利用したり、ホットマルト接着剤等の接着剤を使用したりすることができます。また、液抵抗性シート5には、非伸縮性シートを使用することができます、その場合には、製造工程におけるシートの伸長工程を省く。

【0026】

【発明の効果】この発明に係る生理用ナプキンの表面シートは、臍口とその周辺へ当接すべき部分を除いて液抵抗性シートで被覆してあるから、吸液性コアから逆流する経血で着用者の肌を汚したり、潤滑感を高めたりすることがない。

* 【0027】また、この発明に係る生理用ナプキンの製造方法によれば、液抵抗性シート原反をその中心線に関して左右に揺動するカットラインで左右に二分し、二分した各々を液抵抗性シートとして使用するから、その連続体には廃棄すべき部分が殆ど生じることがない。したがってこの製造方法であると材料の使用に無駄がない。

【図面の簡単な説明】

【図1】生理用ナプキンの部分破断斜視図。

【図2】図1のY-Y線断面図。

【図3】生理用ナプキンの模式的製造工程図。

【図4】液抵抗性シート原反の平面図。

【図5】図3の工程IVにある生理用ナプキンの平面図。

【図6】カットラインの一例を示す図4と同様の平面図。

【符号の説明】

1 生理用ナプキン

2 表面シート

3 裏面シート

4 コア

5 液抵抗性シート

9, 10 端部

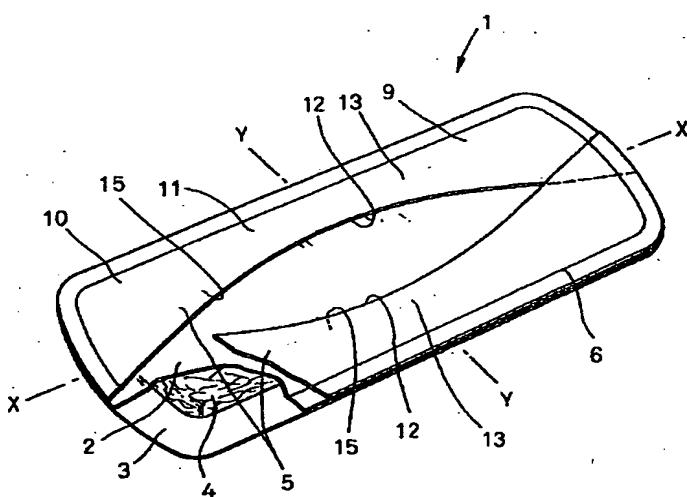
11 中央部

15 ポケット

125 ナプキン本体の連続体

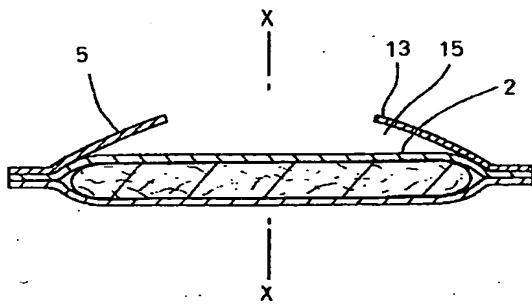
*

【図1】

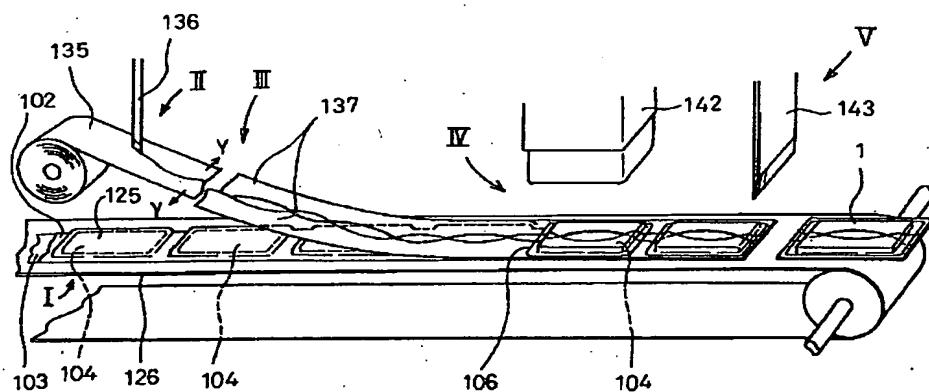


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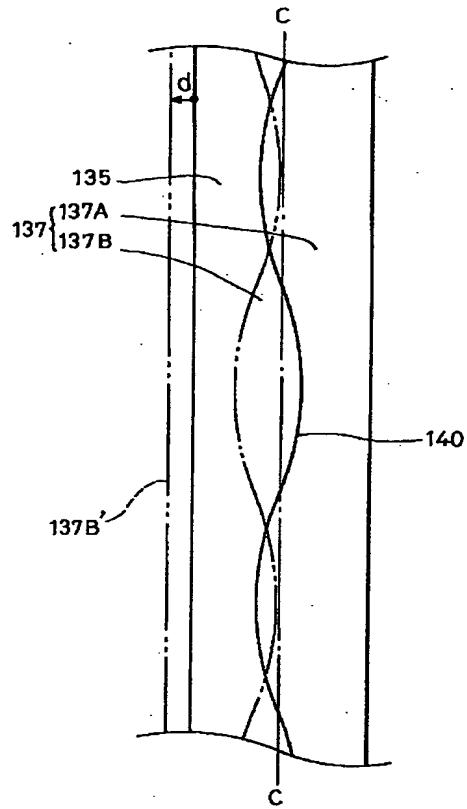
【図2】



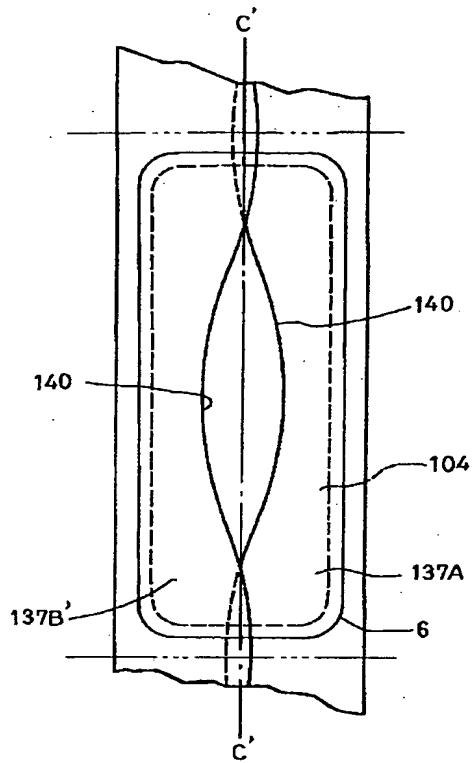
【図3】



【図4】



【図5】



【図6】

